flap is not of the essence of this invention so long as it serves its purpose, as hereinafter described. In cutting blanks from long tubes this flap is cut out from the top of the adjoining blank, leaving a thumb-hole, which is in no wise objectionable. Of course the provision of this flap overcomes the last difficulty in forming the bag, enabling the two final folds to lap and be pasted together in the most approved and secure manner. The bag made by this process, which will form the subject-matter of another application, will, I believe, require less paper for any standard size of bag than any other bag of a similar construction, and said bag is also a thoroughly good and merchantable one.

Reference being now had to the accompanying drawings, which illustrate my invention, Figure 1 is a perspective view of the bag-blank ready for folding into my improved bag. Fig. 2 is a top view of the same blank. Fig. 3 represents the blank as it appears when the diamond has been opened out. Fig. 4 represents the completed bag. Fig. 5 shows in perspective the bag opened up, and Fig. 6 is a perspective view of a slightly-modified form of my bag.

A designates the blank.

B represents the front, and C the back, of the bag-blank.

D D′ are the folded-in sides of the blank.

b b are the front corners, and *c c* the back corners, of the blank.

b′ b′ indicate the two slits made in the front B of the blank, and *c′ c′* the two slits made in the back C of the blank, b^2 c^2 being the flaps which these slits form.

c^3 is the extended or prolonged flap, which I make on the front or back of the blank. As shown, it is on the back and forms a prolongation of the flap c^2.

c^4 indicates a portion at the top of the back C of the blank, which is cut away to form the flap c^3 on another blank when the blanks are cut out of a long tube of paper.

d is the central fold of the tucked-in sides, by which they are divided evenly into laps D and D′, as shown.

The first step in making the bag is to select the line on which the diamond shall be opened.

E, Fig. 2, indicates such a line which must be at a distance from the bottom end of the blank equal to the breadth of the tucked-in side—that is, the distance *e e*, Fig. 2, must be substantially equal to the distance *f f′*, Fig. 5, which is of course the breadth of the sides of the bag.

The next step in making the bag is to open up the diamond on the line E, which results as shown in Fig. 3, where F F represent the side folds of the diamond, the slits *b′* and *c′* having been made so that the flaps b^2 and c^2 shall be as much broader than the distance between the two side flaps F as may be necessary to enable them, when folded down, to overlap such flaps sufficiently to form a pasted seam therewith. The final folds of the bag are made by folding the two ends of the diamond, which I have marked G and G′, on the line *f f* and *f′ f′*, respectively. The result of these final folds is seen in Fig. 4, which shows that while the the flaps b^2 and c^2 just meet at the center of the bottom, the prolonged flap c^3 overlaps the flap b^2, enabling the flap G and the flap G′ to be properly secured together, while each of such flaps is secured to the side folds F by the overlapping edges of the flaps b^2 and c^2 and any desired lines of pasting on the parts behind such flaps.

Fig. 6 represents the prolongation b^3 on the flap b^2 similar to the prolongation c^3 on the flap c^2. Such a construction is of course perfectly feasible, but has, I believe, no good quality which makes it preferable to the plan shown in the other figures of the drawings.

While of course the flap G′ could be folded down first and the flap G folded on top of it, I believe that it will be found more convenient to secure the lap c^3 on the flap b^2 rather than to secure the flap b^2 on top of the flap c^3.

To avoid confusion in the lines, I have omitted to represent in the drawings the usual lines of paste by which the flaps G and G′ are secured to each other and to the side folds F F in forming the bottom. To all skilled in the art it will be obvious how and where such paste-lines should be applied, and it is therefore unnecessary to further refer to them.

In the drawings I have, for the sake of clearness, represented the flap c^3 as narrower than the flap c^2, of which it is a prolongation. In practice, however, these flaps should be of the same breadth, or, at least, the base of c^3 should be as broad as c^2. Its corners may be curved, if desired.

Having now described my invention, what I claim as new, and desire to secure by Letters Patent, is—

As a new article of manufacture, a bellows-sided satchel-bottomed paper bag having its bottom formed with side folds substantially equal in breadth to one-half the breadth of its tucked-in sides, its final folds formed with parallel-sided flaps of such a breadth that they will overlap the said folds sufficiently to form a strong pasted seam therewith, and a prolongation of one of the flaps sufficient in length to overlap and form a pasted seam with the other flap.

CHAS. B. STILWELL.

Witnesses:
LISLE STOKES,
FRANCIS T. CHAMBERS.